



DESIGN <i>MM</i>	DRAWN BY <i>MM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KS</i>	DRAWING NO. D2785	REV. A SHEET 1 OF 2
DATE 98.08.13		TITLE 427 STD SKIDTUBE ASSEMBLY	SCALE NTS
A	98.08.13	NEW ISSUE	

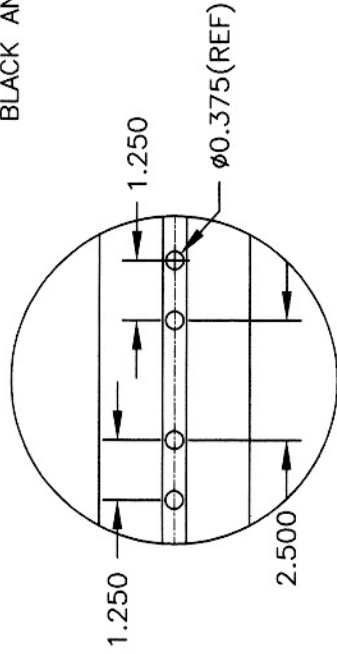
RELEASED
98.8.25 DS

Qty	Part Number	Description
X	D2785-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
5	D2648-3	WEARPAD
2	D2648-5	WEARPAD
18	D2649	CROSS BOLT SPACER
12	D2651-1	PLUG
12	D2651-3	O-RING
1	D2786	WEB
1	D2794	CAP
54	ALS4-1032-130 or AKS7-1032-130	INSERT
56	AN960JD10L	WASHER
56	MS27039-1-08	BOLT

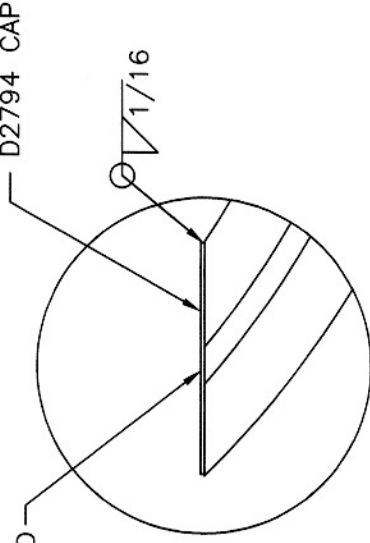
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 120 INCHES.*
- 3) INSERT D2786 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8161 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS4-1032-130 PER SECTION D-D (54 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2786 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).

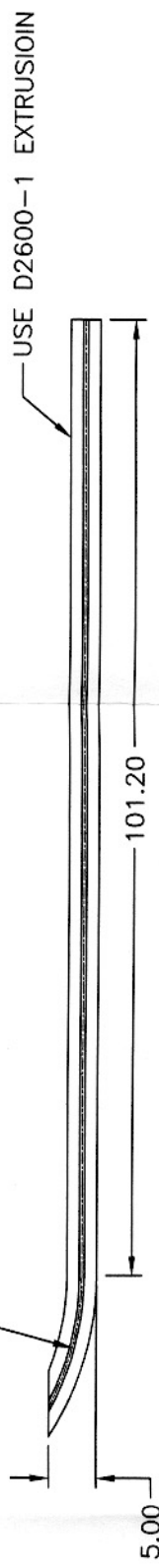
DETAIL A
SCALE 1:4



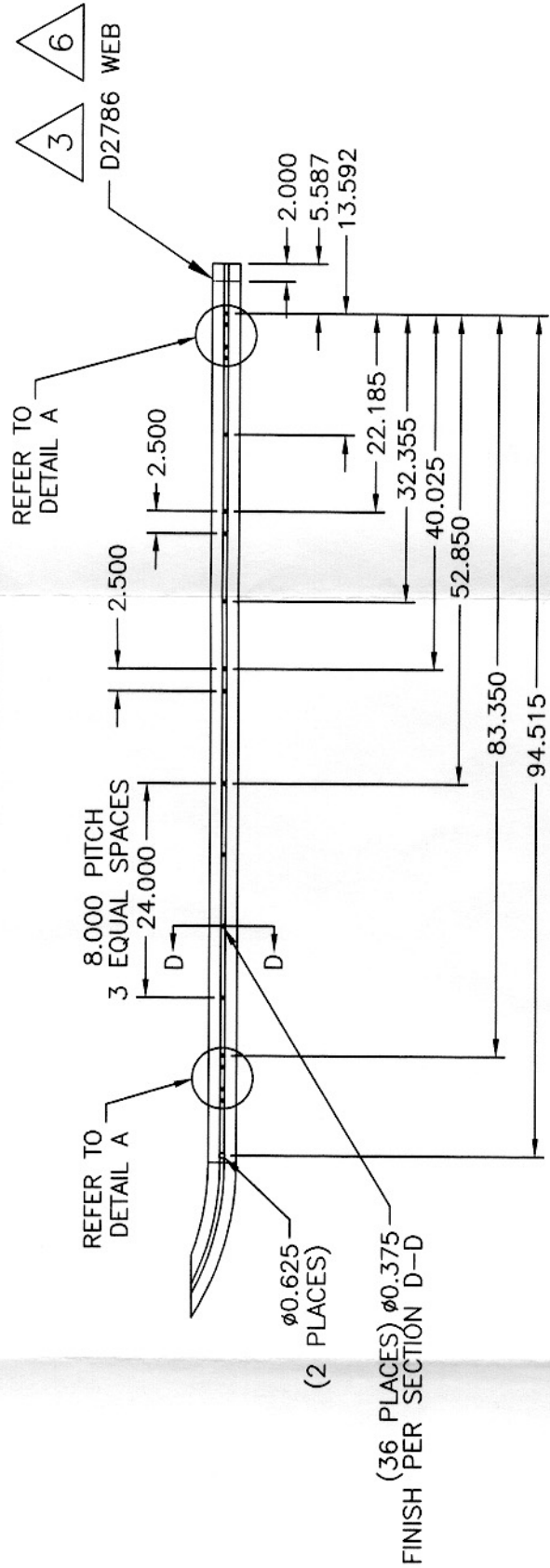
DETAIL B
SCALE 1:4



D2785-1 BENDING DETAIL



D2785-1 DRILLING DETAIL



SECTION D-D
SCALE 1:4

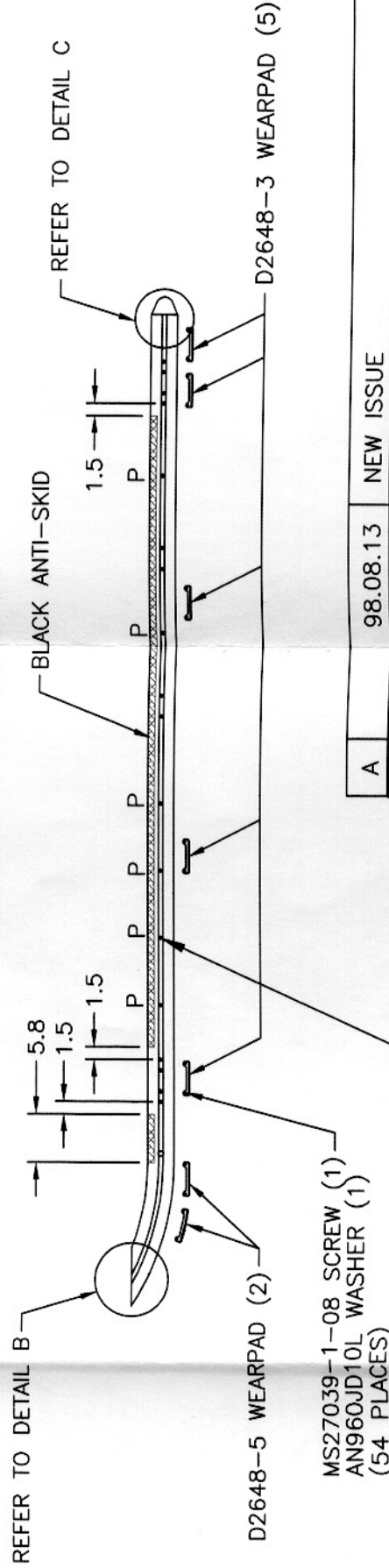
FOR 0.375 HOLES ONLY



- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER (18 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C-BORE D2649 SPACER TO 0.313 X 0.75 DEEP

ALS4-1032-130 (REF)
(TYP 54 PLACES)

D2785-041 ASSEMBLY DETAIL



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CHECKED	DATE	DRAWING NO.	REV. A
KE	98.08.13	D2785	SHEET 2 OF 2
		TITLE	SCALE
		427 STD SKIDTUBE ASSEMBLY	1:20

RELEASED
R 98 8 15 DS